

Work Order ID 147752

June 10, 2016 4:04:26 PM

147752

Page 1

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Stop

NS2

Start Date: 6/10/2016 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/14/2016 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan: SH

Date: 6/10/16

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

110

110

Large Fab

Large Fab

0.00

Memo

1.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 134826

3-Grind End Plate flush

→ C/ 16-07-07

B147752 (X15RH)

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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147752

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Stop *NS2*

Start Date: 6/10/2016 **Start Qty:** 15.00 ***15***

Cust Item ID:

Required Date: 7/14/2016 Req'd Qty: 15.00 *15*

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** ____/____/____ **Tooling:** _____ **Date:** ____/____/____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

DAS

— 9

9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.05

Quality Control

DAS

9

— 9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

1.03

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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OTHER :									

Work Order ID 147752

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June 10, 2016 4:04:26 PM

Item ID: D350-591-312 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 6/10/2016 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 7/14/2016 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.03							
Quality Control									
180	Large Fab	0.00							
180									
Large Fab	Memo	1.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

15BM f ll 16/02/16 68-6 51 DAS
 15x CC 16-7-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
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Past Expiry Date	☐	Manufacturing Process	☐								
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Work Order ID 147752

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Item ID: D350-591-312
 Revision ID:
 Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 6/10/2016 Start Qty: 15.00
 Required Date: 7/14/2016 Req'd Qty: 15.00
 Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M 134798</i> Memo START TIME: <i>7:50</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>8:20</i>	0.00 0.53				<i>15</i>	<i>1607-18</i>		<i>938</i>
230 *230* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M 134948</i> Memo	0.00 0.55				<i>RHx15</i>	<i>16/07/19</i>		<i>DAS 15 9:00</i> <i>BEB</i>
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03				<i>(15)</i>			<i>DAS 38 9:00</i> JUL 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

Work Order ID 147752***147752***

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Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Stop ***NS2***

Start Date: 6/10/2016 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/14/2016 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.03							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.08							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location :FG072								

sold X/S

15

DAS
27
9-89

JUL 20 2016

15

DAS
27
9-89

JUL 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 147752***147752***

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Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Stop ***NS2***

Start Date: 6/10/2016 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/14/2016 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280DAS
21
9-89

JUL 20 2016

QC

Memo

0.25

Quality Control

DAS
21
9-89

JUL 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

June 10, 2016 4:04:31 PM

Page 1

Work Order ID: 147752

147752

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D
fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3272-1 Step		Manufactured	No			110	Each	0.0000	1	15			
D3272-1													
✓ D3067-1 End Plate		Manufactured	No			110	Each	91.0000	1	15			
D3067-1													
					<u>Location</u>			<u>Loc Qty</u>					
					WA003			91					
					142780			5					
					146702			86					
✓ D3219-1 Plate		Manufactured	No			110	Each	60.0000	2	30			
D3219-1													
					<u>Location</u>			<u>Loc Qty</u>					
					WA003			60					
					142668			40					
					144410			20					
✓ D3066-1 Spacer		Manufactured	No			180	Each	0.0000	2	30			
D3066-1													

**** 3146691 → 15 JUL 06 2016 DAS 24 9-89**

**** 15 JUL 06 2016 DAS 24 9-89**

**** 30 JUL 06 2016 DAS 24 9-89**

~~3145080 → 12~~
3146684 → 12

**** 30 16-07-12**

3146104 → 25

3146706 → 5

Picklist Print

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Work Order ID: 147752

147752

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

MS20600-AD4W4

Purchased

No

180

Each

2,024.000

16

240

**

240 *CP* 16-07-12

MS20600-AD4W4

Rivets

Location

Loc Qty

Loc Code

CCK005

1982

M133990

1482

M134955

500

ST308

42

M132640

42

240

D3065-041

Manufactured

No

180

Each

7.0000

1

15

**

PC

D3065-041

Step Leg Assembly

Location

Loc Qty

Loc Code

WA002

7

144118

3

144982

1

145083

3

B145654
B145081

D3067-1

Manufactured

No

180

Each

91.0000

1

15

**

B145081 PC

D3067-1

End Plate

Location

Loc Qty

Loc Code

WA003

91

142780

5

146702

86

Picklist Print

June 10, 2016 4:04:31 PM

Work Order ID: 147752

147752

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

AN3-35A

Purchased

No

250

Each

217.0000

2

30

AN3-35A

Bolt

**

PC

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

122800

10

over003

100

m134943

100

30

ST348

107

m134167

50

m134497

57

D3235-1

Manufactured

No

250

Each

70.0000

2

30

D3235-1

Mounting Lug

**

B146290 X 30

DAS
27
9-89

Location

Loc Qty

Loc Code

ST521

20

143809

20

ST546A

50

142565

50

D3278-041

Manufactured

No

250

Each

23.0000

1

15

D3278-041

Support Assembly

**

B145581

DAS
6
9-89

Location

Loc Qty

Loc Code

ST522

23

145580

23

JUL 13 2016

SmB

Picklist Print

June 10, 2016 4:04:31 PM

Work Order ID: 147752

147752

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

NAS1149D0463J

Purchased

No

250

Each

3,625.000

16

240

NAS1149D0463.J

WASHER

**

PC

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	86	
M132035	21	
M134508	65	
ST260a	2000	
M134852	1000	240
M134943	1000	
ST263	1539	
M134754	1539	

NAS1149D0563J

Purchased

No

250

Each

957.0000

4

60

NAS1149D0563.J

Washer

**

PC

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	231	
m125807	2	
m133769	229	
ST263	627	
m134497	627	60
ST269	99	
m128257	99	

AN5-36A

Purchased

No

250

Each

167.0000

2

30

AN5-36A

Bolt

**

PC

DAS
27
9-89

Location

Loc Qty

Loc Code

over004	120	
M134861	120	30
ST336	47	
M130466	15	
M134676	32	

JUL 13 2016

Picklist Print

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Work Order ID: 147752

147752

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

D2618

Manufactured No

250

Each

139.0000

2

30

D2618

Bushing

**

X6 147525 PC

DAS
27
9-89

Location

Loc Qty

Loc Code

ST008A

139

144670

39

146622

100

D2230-3

Manufactured No

250

Each

175.0000

4

60

D2230-3

Mounting Lug

**

X24 - B146 287 PC

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

67

142522

1

143805

66

ST525A

100

144487

60

145363

40

D2856-400

Manufactured No

250

f

327.1632

1,2

18

***D2856-400*-720**

Abrasion Strip 4" Wide (Per Foot)

**

B146 220X30

DAS
27
9-89

Location

Loc Qty

Loc Code

ST418

327.16316

141123

111.16316

146265

216

cut (2) D2856-400-720 as per dwg

JUL 13 2016

Picklist Print

June 10, 2016 4:04:31 PM

Work Order ID: 147752

147752

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

MS21042L3

Purchased

No

250

Each

1,778.000

2

30

MS21042L3

Nut

PC

Location

Loc Qty

Loc Code

FP001

44

m133790

44

GA

269

m133790

3

m134360

266

OVER007

600

m134754

600

ST303

865

m134039

12

m134634

53

m134943

800

30

AN4-13A

Purchased

No

250

Each

732.0000

8

120

AN4-13A

Bolt

PC

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

60

m134167

36

m134634

24

over003

500

m134852

400

m134943

100

ST344

152

m134754

152

120

JUL 13 2016

Picklist Print

Page 7

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Work Order ID: 147752

147752

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

MS21042L5

Purchased

No

250

Each

583.0000

2

30

MS21042L5

Nut

**

PC

DAS
9-89

Location

Loc Qty

Loc Code

GA	95
m127813	95
OVER007	250
m134509	100
m134955	150
ST303	238
m134055	6
m134676	32
m134762	200

30

DAS
27
9-89

MS21042L4

Purchased

No

250

Each

2,264.000

8

120

MS21042L4

Locknut

**

PC

DAS
9-89

Location

Loc Qty

Loc Code

GA	181
m133769	181
OVER007	1000
m134861	1000
ST303	989
m134762	489
m134955	500
ST305	94
m130922	94

120

DAS
27
9-89

JUL 13 2016

Picklist Print

June 10, 2016 4:04:31 PM

Work Order ID: 147752

147752

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/10/2016

Required Date: 7/14/2016

Start Qty: 15.00

Required Qty: 15.00

NAS1149D0363J

Purchased

No

250

Each

2,284.000

4

60

NAS1149D0363J

Washer

PC
DAS
6
JUL 13 2016

Location

Loc Qty

Loc Code

GA	465	
m134055	465	
ST263	1819	
m134606	8	
m134676	811	
m134955	1000	

60

DAS
27
9-89

DART

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04 H*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

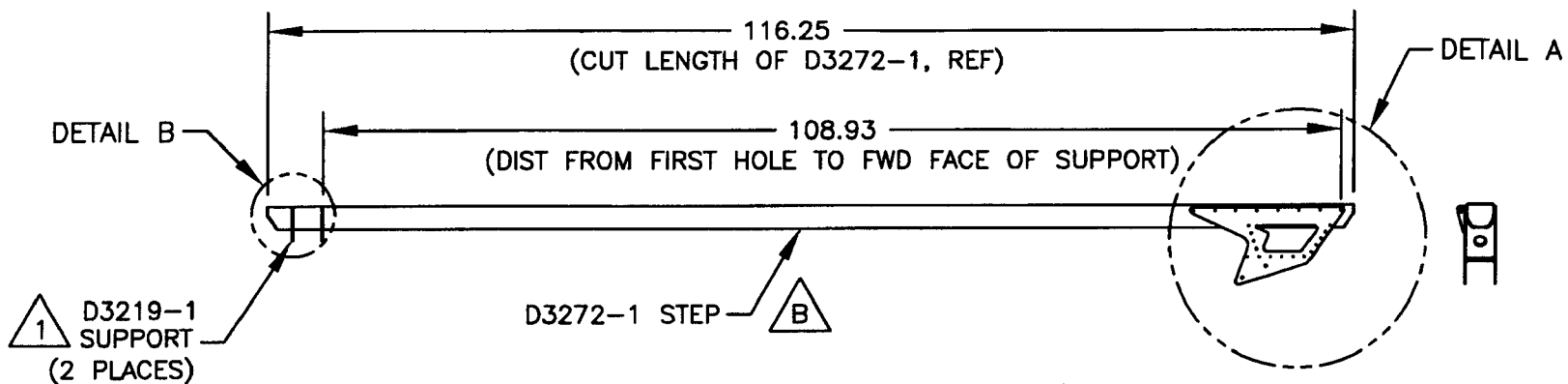
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*SH 147751
6/10/16***Copyright © 2004 by DART AEROSPACE LTD**

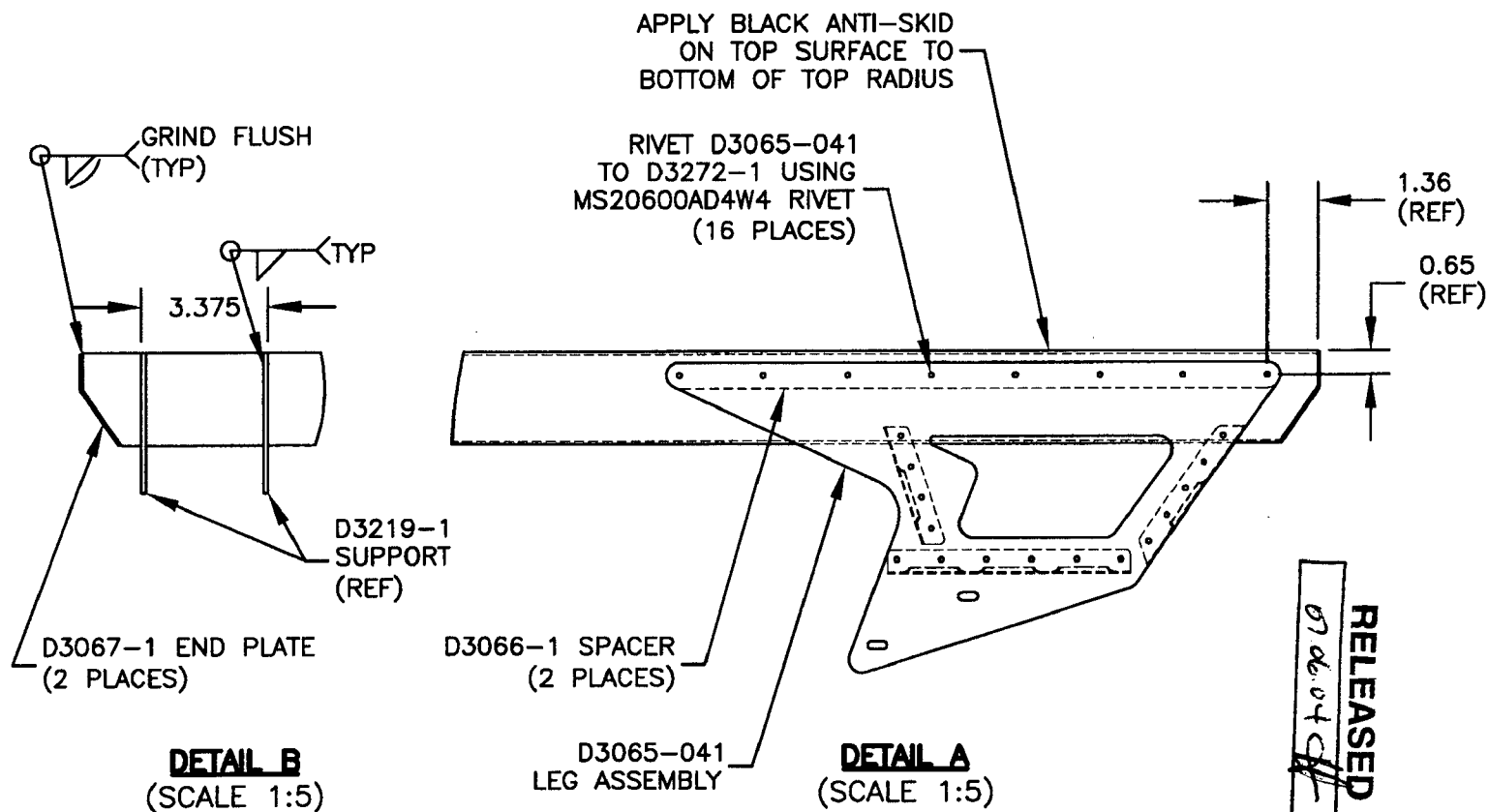
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
07.05.18	D3272	SHEET 2 OF 3
	TITLE	SCALE
	STEP ASSEMBLY, HI LONG	1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

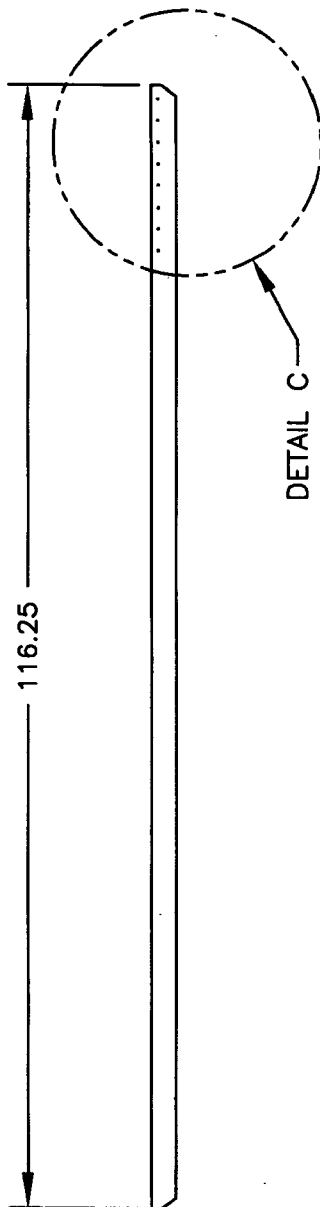




DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

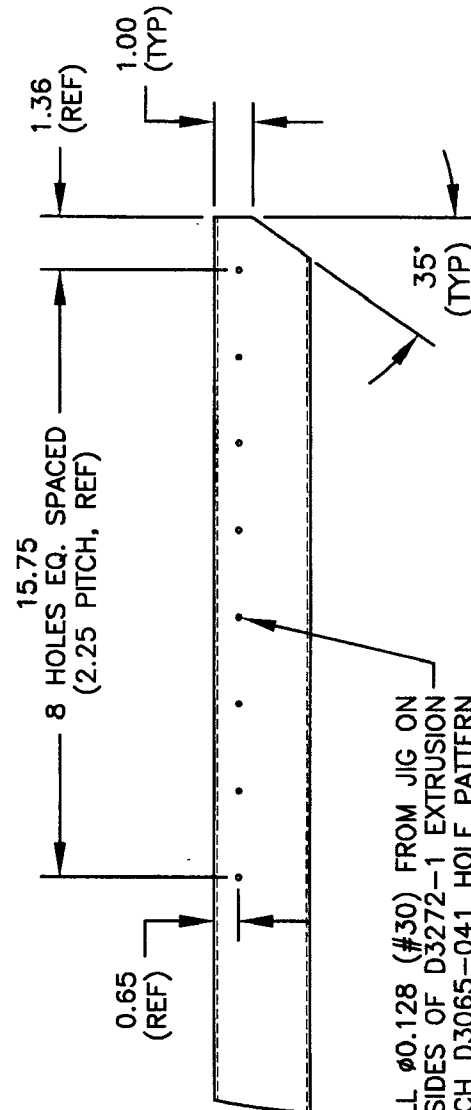
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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JUL 12 2016

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
8	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.